

Work Order ID 74526

Tuesday, October 04, 2011 8:17:51 AM



Page 1

Item ID: D3536-25

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: WAXXAVO

Date: 11/10/04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B11-10-11

(14)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-10-11

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S wkslu

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, October 04, 2011 8:17:51 AM

Page 2



Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start



Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



**Insp.
Stamp**

Identify as per dwg & Stock Location: FP-2

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



OC

Memo

0.00

Quality Control

14 BK 11-10-11.

11/10/12 ~~12~~
ME
11-10-11

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Picklist Print

Tuesday, October 04, 2011 8:17:55 AM

Page 1

Work Order ID: 74526

Parent Item: D3536-25

Parent Item Name: Gasket



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	636.8500	0.5956	7.941333	8.5		
NEOPRENE SHEET 0.063													

811-10-11

Location

Loc Qty

Loc Code

-MAT052

636.85

117295

55.68

118026

127.87

118663

73.3

119130

380

118663

14

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DART AEROSPACE LTD		Work Order: 74526
Description: Gasket		Part Number: D3536-25
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	✓		TP B01	
16.35	+/-0.030	16.35	✓		TP	
10.90	+/-0.030	10.90	✓		TP	
5.45	+/-0.030	5.45	✓		T	
6.00	+/-0.030	6.00	✓		T	
6.75	+/-0.030	6.75	✓		T	
12.75	+/-0.030	12.75	✓		T	
1.89	+/-0.030	1.890	✓		V B07	
0.30	+/-0.030	.301	✓		V	
0.30	+/-0.030	.304	✓		V	
Ø0.19	+0.005/-0.001	.190	✓		V	

Measured by: R	Audited by: S	Prototype Approval:	N/A
Date: 11-10-11	Date: 11/10/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	ER

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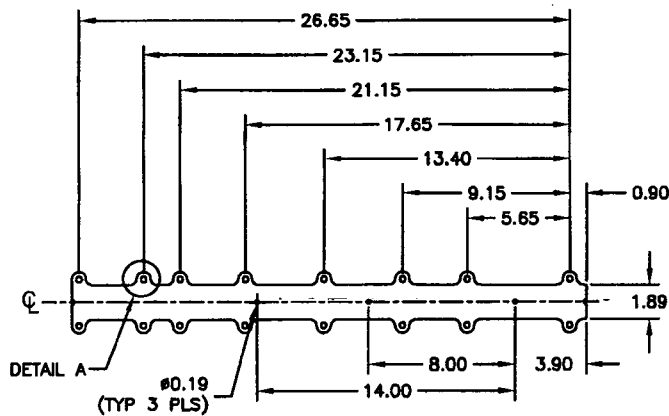
NOTE: Date & initial all entries

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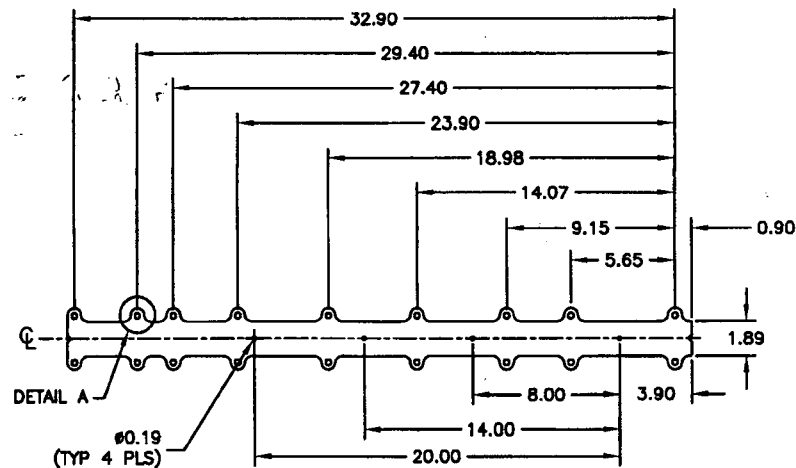
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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74526 M.C.J

11/10/04



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	SCALE 1:10
A	06.10.25	NEW ISSUE	

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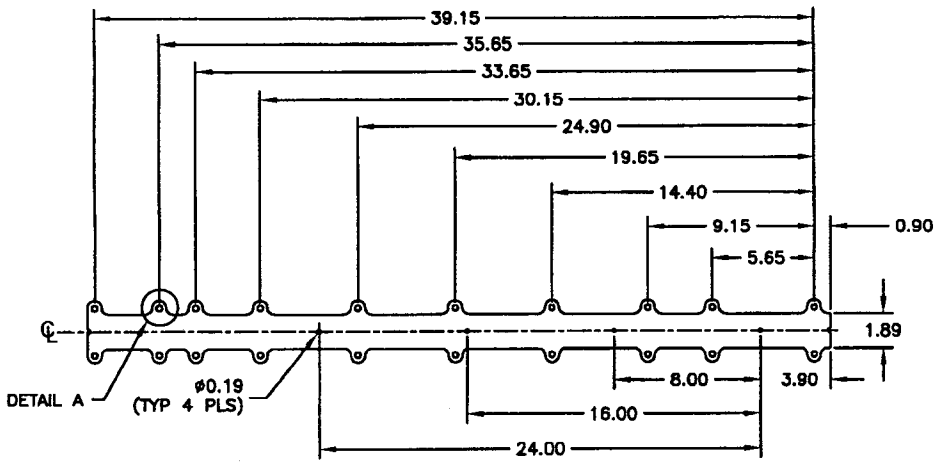
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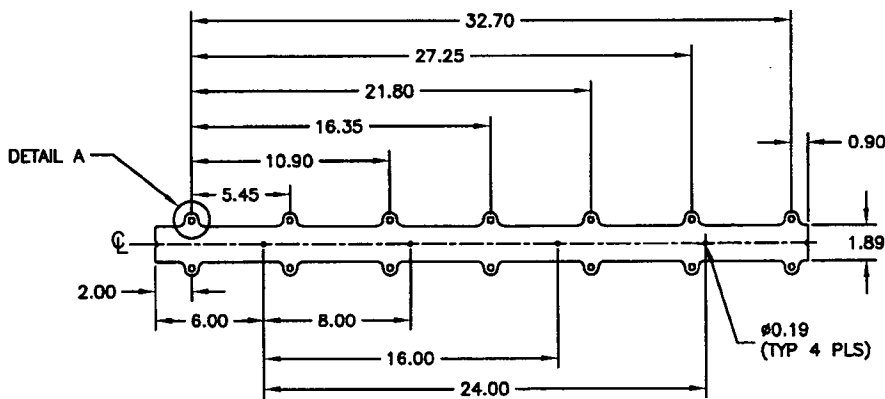


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		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	



D3536-15 GASKET



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
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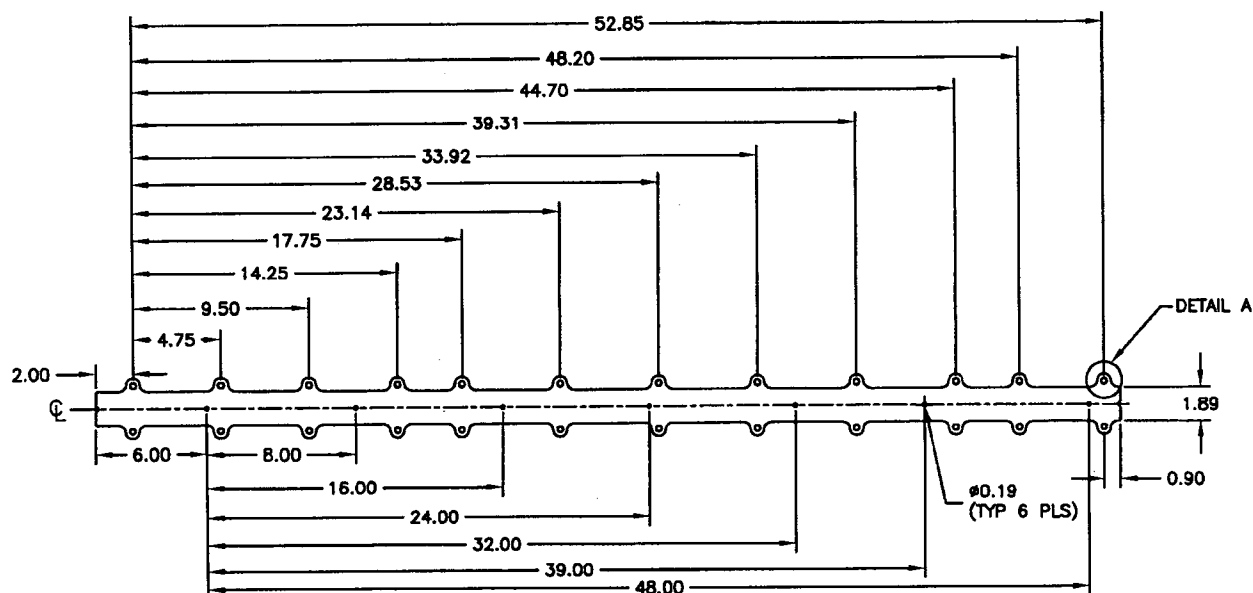
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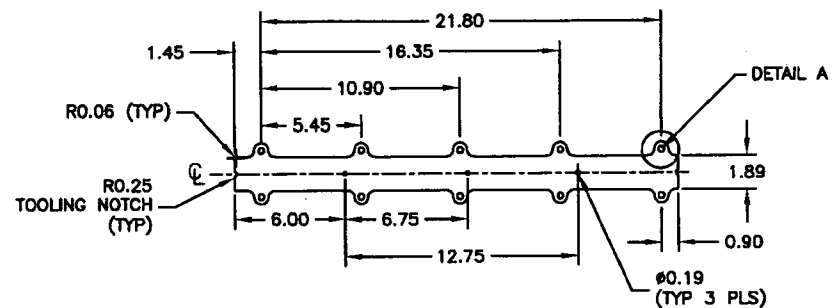
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D3536-23 GASKET



D3536-25 GASKET

NOTES

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				SHEET 3 OF 6
				SCALE 1:10

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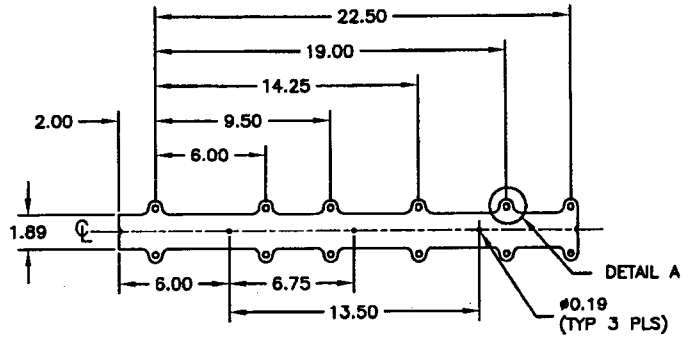
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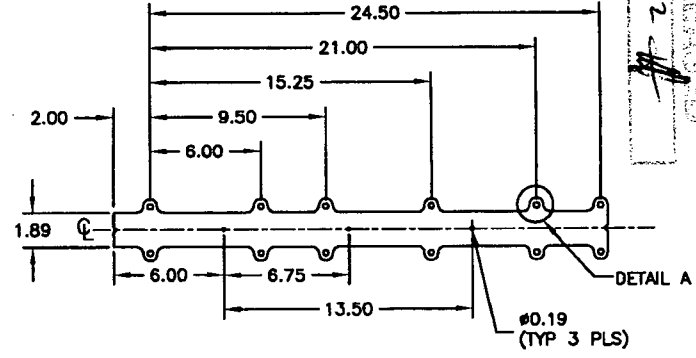
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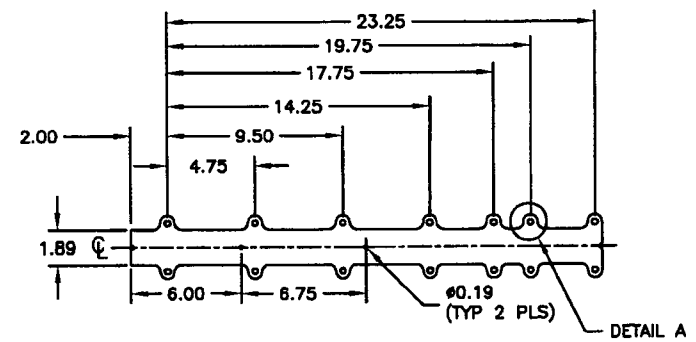
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D3536-31 GASKET



D3536-33 GASKET



D3536-35 GASKET

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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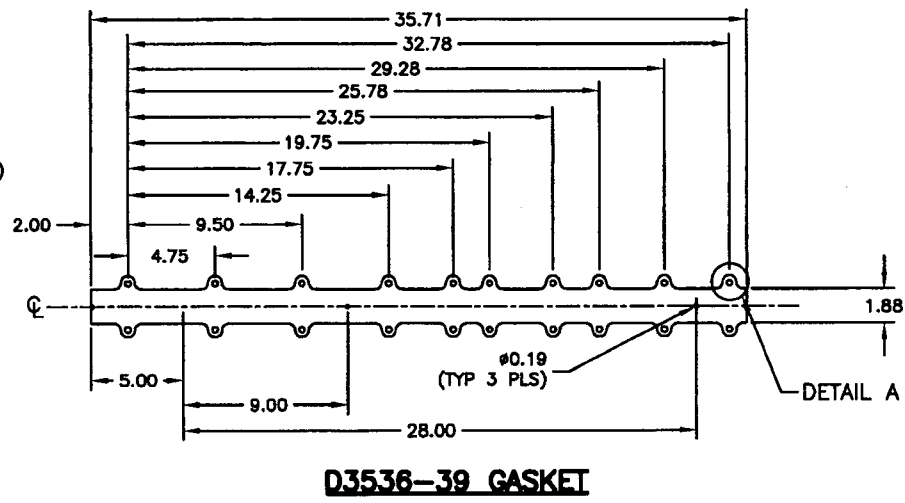
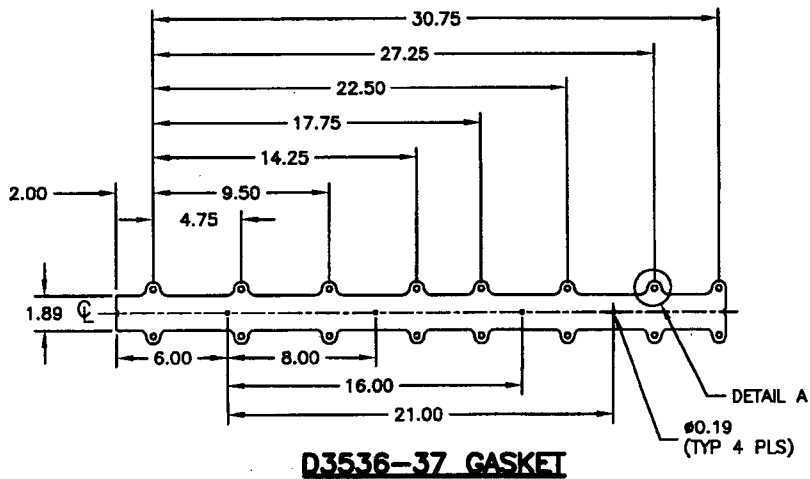
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DATE 06.10.25	TITLE GASKET	SHEET 5 OF 6	SCALE 1:10

07.02.12
CH



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO80-S.063)
- 2) FINISH: NONE
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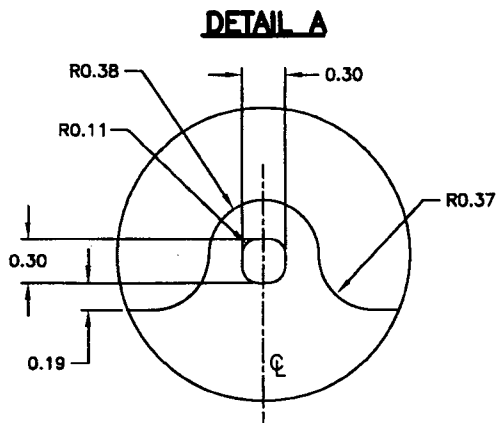
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DATE 06.10.25	TITLE GASKET		SCALE 1:10



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